

Date: Monday, 11/05/2009 1:39:37 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BAR
Job Number : 47878	
Estimate Number : 13480	
P.O. Number :	Part Number : D38061
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D3806 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 46624	Material :
Written By :	Due Date : 25/05/2009 Qty: 2 Um: Each
Checked & Approved By : <u>Julie Dawson 09-05-11</u>	
Comment : Est Rev:A 08-07-21 new issue DD verified by:ec Est Rev:B 08-09-23 redesign DD verified by:EC Est Rev:C 08-09-30 redesign DD verified by:EC Est Rev:D 09-03-04 rev.a as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0500X2500	304 BAR .500 x 2.50
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Comment: Qty.: 0.8820 f(s)/Unit Total: 1.7640 f(s)
 304 BAR .500 x 2.50
 batch: 110330 RB 9-5-26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3806
 Dwg Rev: A
 Prog Rev: A RB 9-5-26
 2-Deburr if necessary

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/05/27 (2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-drill holes as per dwg D3806
 2-deburr

FF 09-05-27 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:39:37 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 47878

Part Number: D38061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/27 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/O B47723

EL 9-5-27 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/27 (2)

Job Completion



MF
09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

C

B

B

D3806-1 BAR

D3806-5 BAR

D3806-3 BAR

D3806-7 BAR

RELEASED
 07 09.03.03
 per ECN 09-538

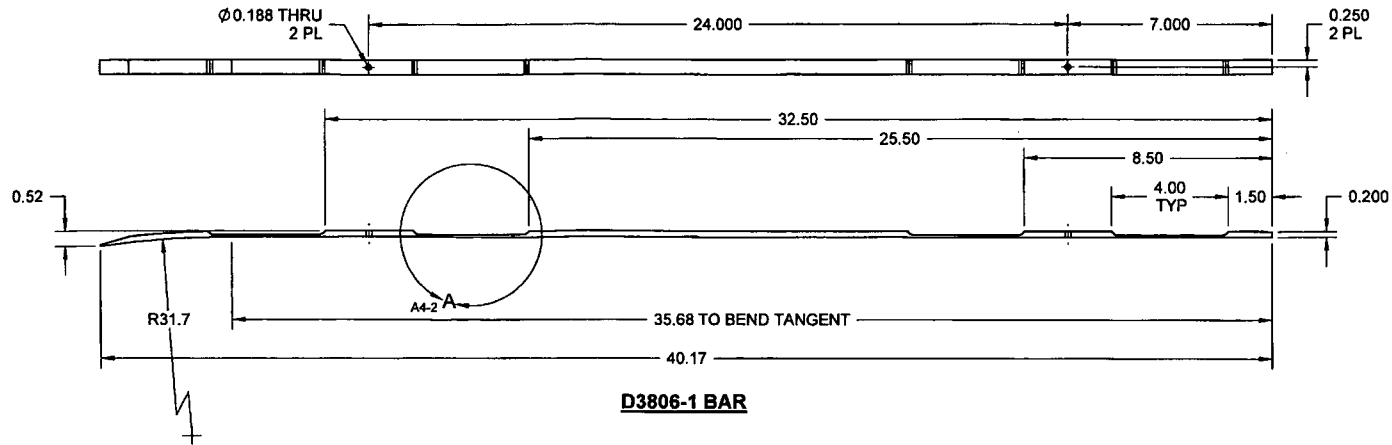
NO. 42878
 WORK ORDER
 SHOP COPY
 RETURN TO
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3806	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

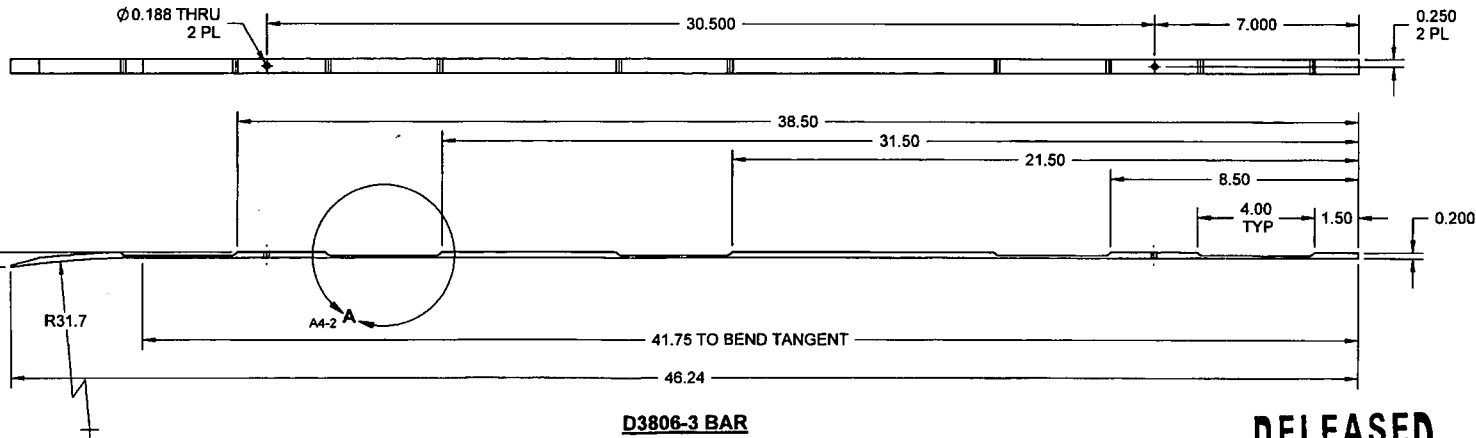
8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

0.500
REF



D3806-1 BAR

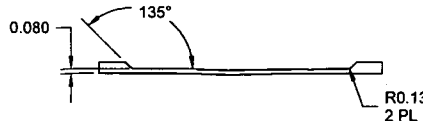


D3806-3 BAR

RELEASED
09.13.03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-1 = 0.87 lbs
D3806-3 = 0.98 lbs



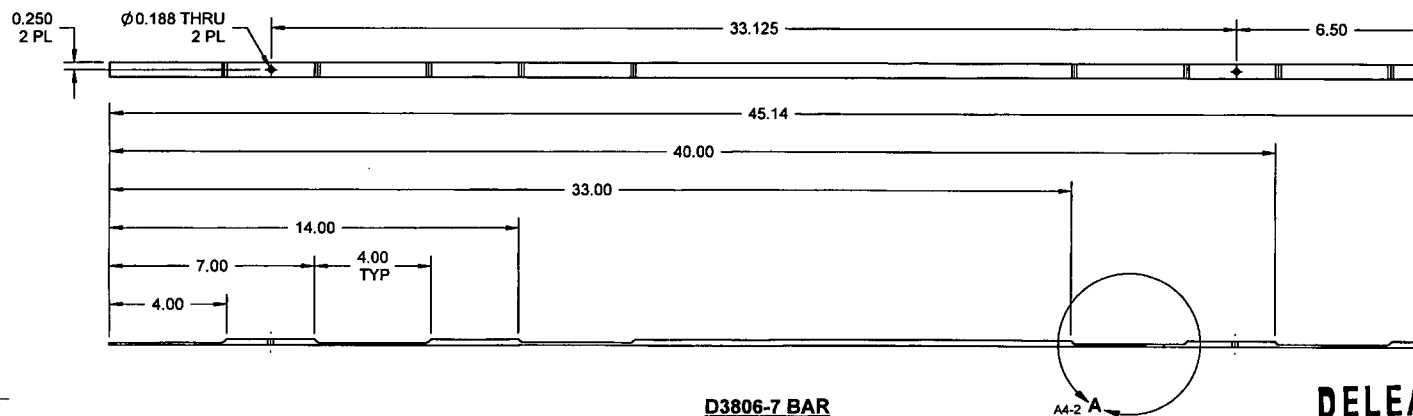
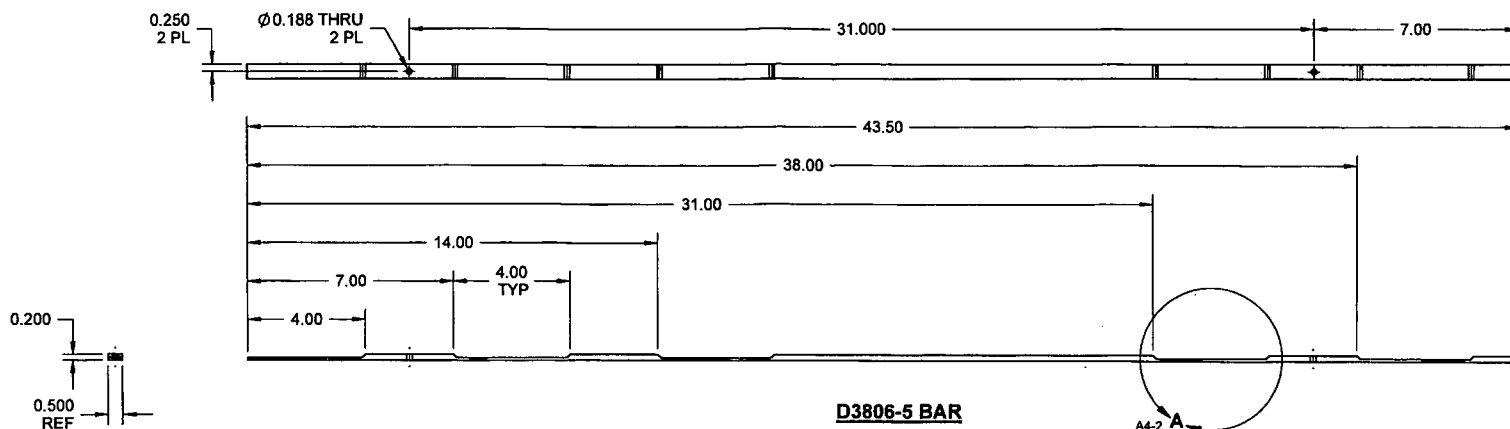
DETAIL A
TYP, SCALE 2X
D5-2
B6-2
C3-3
A3-3

DESIGN	JP	DART AEROSPACE USA, INC.	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3806	SHEET 2 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BAR	NTS
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WORK ORDER
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ENTERING

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



RELEASED
09.03.03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 0.91 lbs
D3806-7 = 0.97 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3806	SHEET 3 OF 3
APPROVED	AS	TITLE	SCALE
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SHOULD BE
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0.500
REF

8 7 6 5 4 3 2 1